

## ABSTRACT

A roof panel (31) is pre-set on the left and right side members (4) fixed to an underbody of a car. A roof panel spot  
5 welding station (7) includes a pair of frames (34) and two  
joisted-locating jigs (35, 36) bridging the frames. Each of  
the joisted-locating jigs is furnished with a clamp mechanism  
for holding the roof panel. The roof panel is located to the  
side members by the locating jigs, and spot-welded to the side  
10 members.